

Date: Thursday, 27/11/2008 2:37:42 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BEARPAW INSTALLATION
<b>Job Number</b> : 43831	
<b>Estimate Number</b> : 10098	
<b>P.O. Number</b> :	<b>Part Number</b> : D30761
<b>This Issue</b> : 27/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3076 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 25749A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 04/12/2008 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Jul 08.11.27</u>	
<b>Comment</b> : Est Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM	
Est Rev:D 08-11-10 New Manufacturing Method JLM	
Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MUHMWB10	UHMW 1" Black
<b>Comment:</b> Qty.: 1.0000 sf(s)/Unit Total : 2.0000 sf(s) Pick: blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12 Material: Black UHMW 1"(MUHMWB10) Batch: <u>109186</u> <u>18 8-12-2</u>		
2.0	MFG ENGINEERING	MFG ENGINEERING
<b>Comment:</b> MFG ENGINEERING Program Batch Number		
3.0	WATER JET	FLOW WATER JET
<b>Comment:</b> FLOW WATER JET Cut Blank as per file D3076-1_BLANK		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Note: (2) Bearpaw for (1) Kit  1-Inspect material for defects or damage prior to machining  2-Machine as per Folio FA186 and Dwg D3076  3-Identify as D3076-1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 43831

Part Number: D30761

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/01/11

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/11 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: #44705

CMF 09-01-13

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14

Job Completion



CMF 09-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43831
<b>Description:</b> R22 Bearpaw		<b>Part Number:</b> D3076-1
<b>Inspection Dwg:</b> D3076 <b>Rev:</b> A1		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	.075x45°	✓			
B	0.63	+/-0.030	.631	✓			
C	0.250	+/-0.010	.252	✓			
D	0.950	+0.030/-0.010	.953	✓			
E	5.50	+/-0.030	5.502	✓			
F	0.25 x 45°	+/-0.030	.270x45°	✓			
G	0.375	+/-0.010	.377	✓			
H	0.475	+/-0.010	.477	✓			
I	5.83	+/-0.030	5.833	✓			
J	3.80	+/-0.030	3.800	✓			
K	3.046	+/-0.010	3.046	✓			
L	3.638	+/-0.010	3.638	✓			
M	0.260	+0.005/-0.000	.260	✓			
N	0.93	+/-0.030	.925	✓			
O	0.30	+0.030/-0.000	.306	✓			
P	7.000	+/-0.010	7.000	✓			
Q	10.14	+/-0.030	10.140	✓			

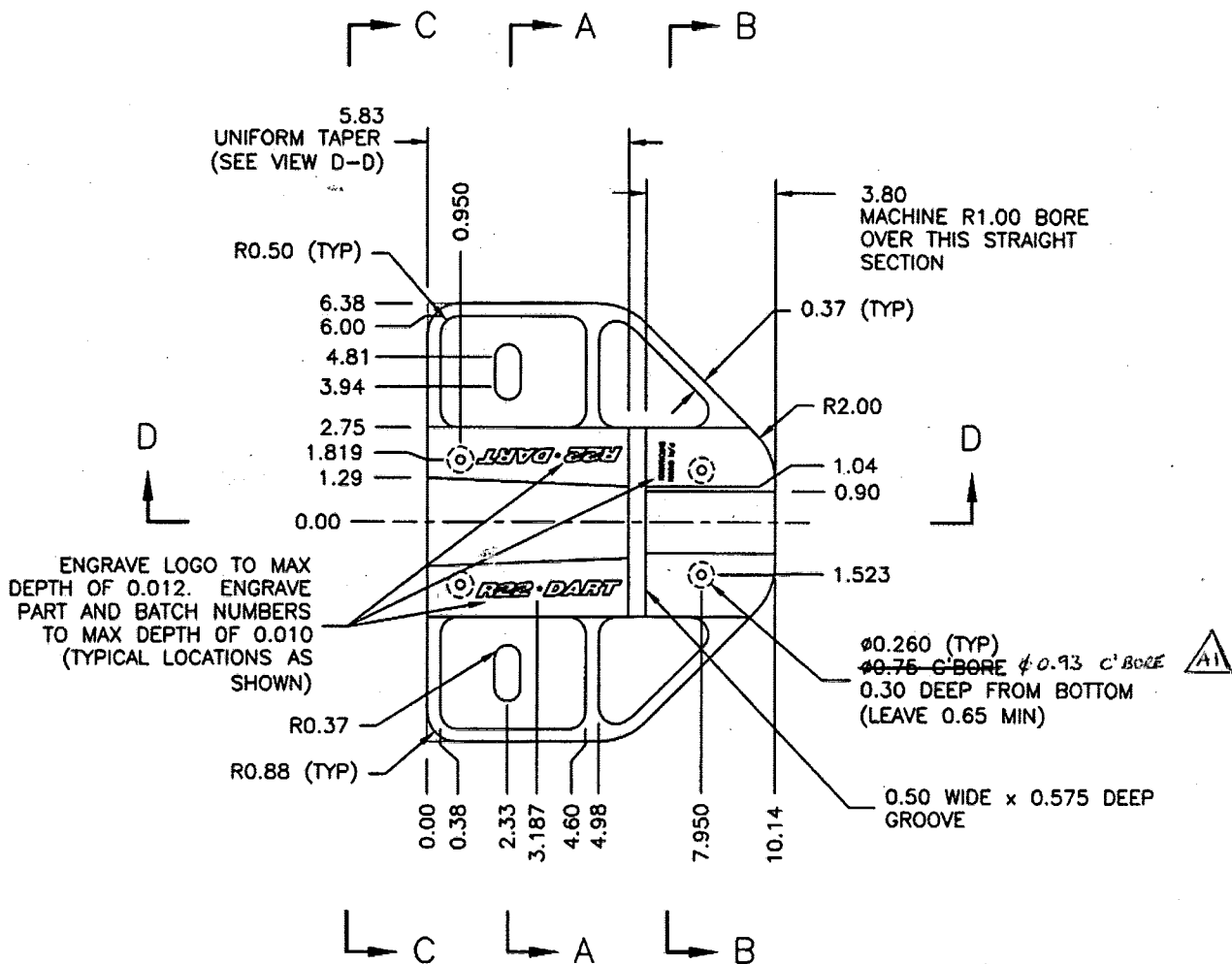
<b>Measured by:</b> J.L.	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09/01/11	<b>Date:</b> 09/01/11	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue      P/O D022-661-011	KJ/RF	✱



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3076	REV. A SHEET 1 OF 2
DATE 02.01.08		TITLE R22 BEARPAW	SCALE 1:5
A	02.01.08	NEW ISSUE	
A1	<del>03.01.06</del>	<del>φ 0.93 WAS φ 0.75</del>	

RELEASED  
02.01.10



D3076-1 BEARPAW (FLAT PATTERN)

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

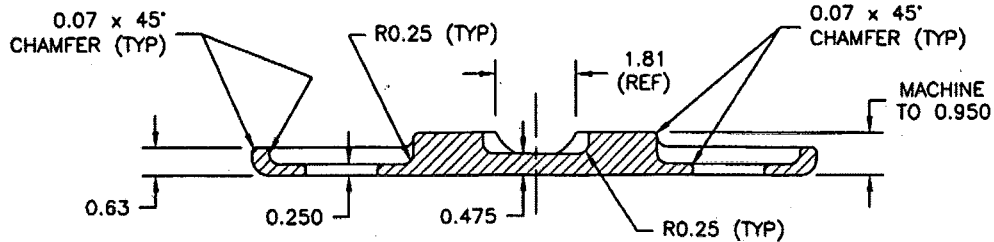
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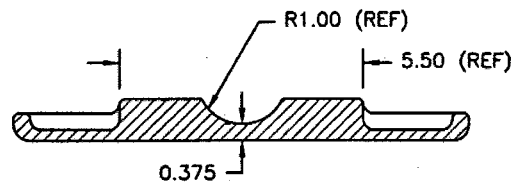
**DART**

DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 02.01.08		TITLE R22 BEARPAW	SCALE 1:4

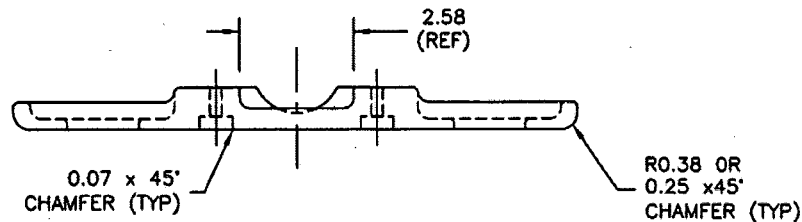


SECTION A-A

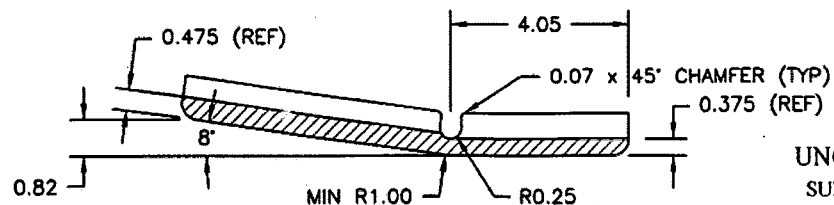
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02.01.10 #



SECTION B-B



SECTION C-C



SECTION D-D (AFTER BENDING)

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